

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77017

Thursday, November 24, 2011 3:22:00 PM

77017

Page 2

Item ID: D3065-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Spacer
 Start Date: 11/24/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 12/5/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab Memo Deburr Stack	0.00 0.00				NA			
140 *140* Brake NC Brake NC	NC BRAKE Memo Bend as per Dwg D3065	0.00 0.00				SS	(51)	(X0)	Ph
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00					(10017)	(X51)	

SI 11/12/20

SI 11/21/21

W/O:		77017 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3005-3 PAR #: Fault Category: Small Fair NCR: (Yes) No DQA: AK Date: 12/01/03
water jet
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: CK Date: 12/01/03

NCR: <u>11-1090</u>		8.84 WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/00	140	1 part Scrap The cut was crooked R-C water jet/Process...	S 11/12/01 057042	Scrap & Destroy No replace	S 11/12/00	S 11/12/01	S 11/12/01 057042	S 11/12/01 057042
		moved during cutting						

NOTE: Date & initial all entries

Thursday, November 24, 2011 3:22:00 PM

Item ID: D3065-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Spacer

Start Date: 11/24/2011 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 12/5/2011 **Req'd Qty:** 40.00

40

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location:

0.00

180

Packaging

Memo

0.00

Packaging

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Work Order ID 77017***77017***

Page 4

Thursday, November 24, 2011 3:22:00 PM

Item ID: D3065-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Spacer

Start Date: 11/24/2011 Start Qty: 40.00

40

Cust Item ID:

Required Date: 12/5/2011 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00


190

QC

Memo

0.00

Quality Control

11/12/23 
mf
11-12-22

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, November 24, 2011 3:22:05 PM

Page 1

Work Order ID: 77017

77017

Parent Item: D3065-3

D3065-3

Parent Item Name: Step Spacer

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.040

Purchased

No

100

sf

76.8184

0.2178

9.170526

M2024T3S 040

**

B11-12-19

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

76.818421

117684

76.818421

117684

SD

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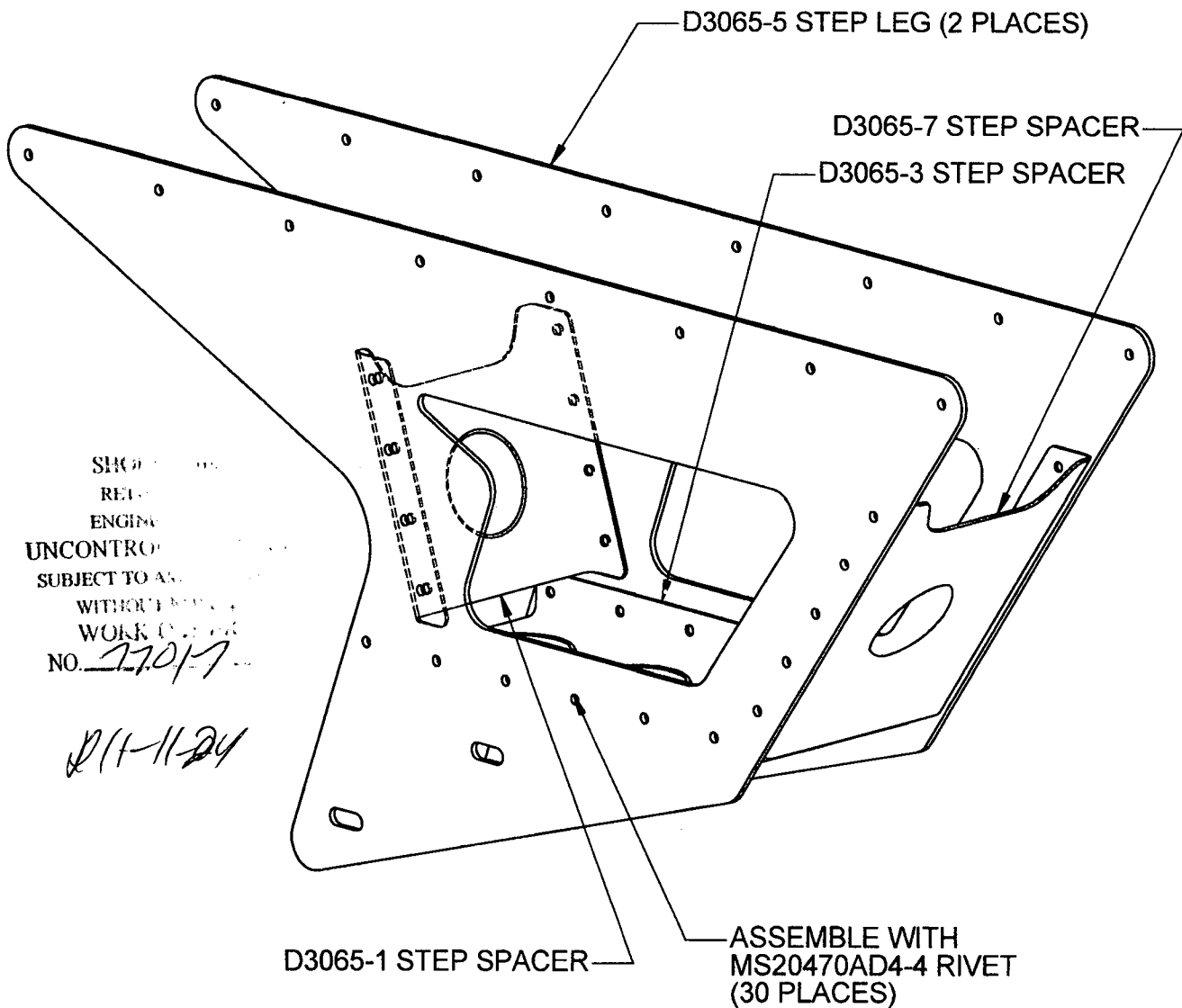
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY SCALE 1:2	
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06-06-20 *[Signature]*



SHOWN
REL
ENGINE
UNCONTROL
SUBJECT TO AS
WITHOUT
WORK
NO. *27017*

DIT-11-24

D3065-041 STEP LEG ASSEMBLY

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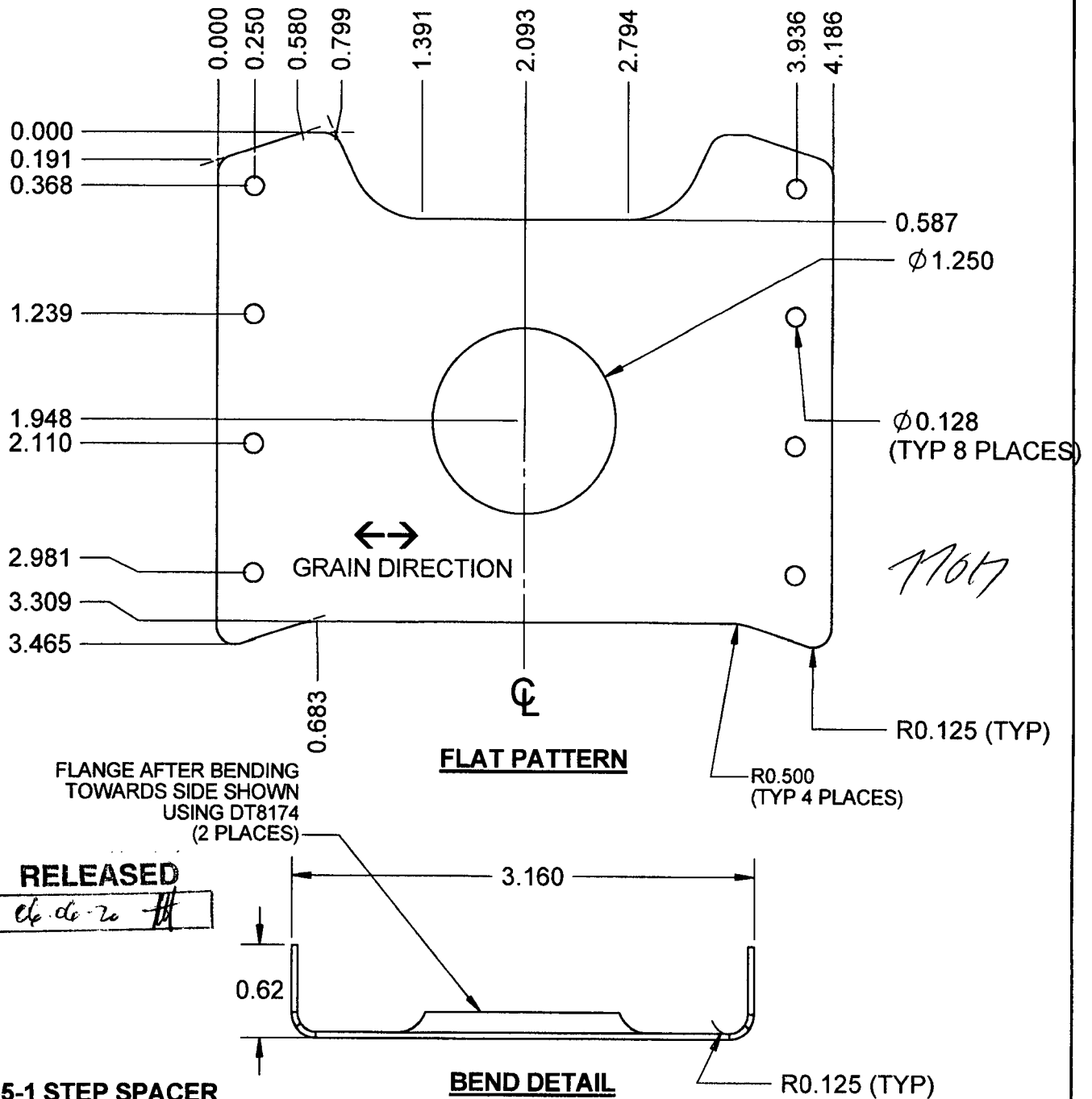
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

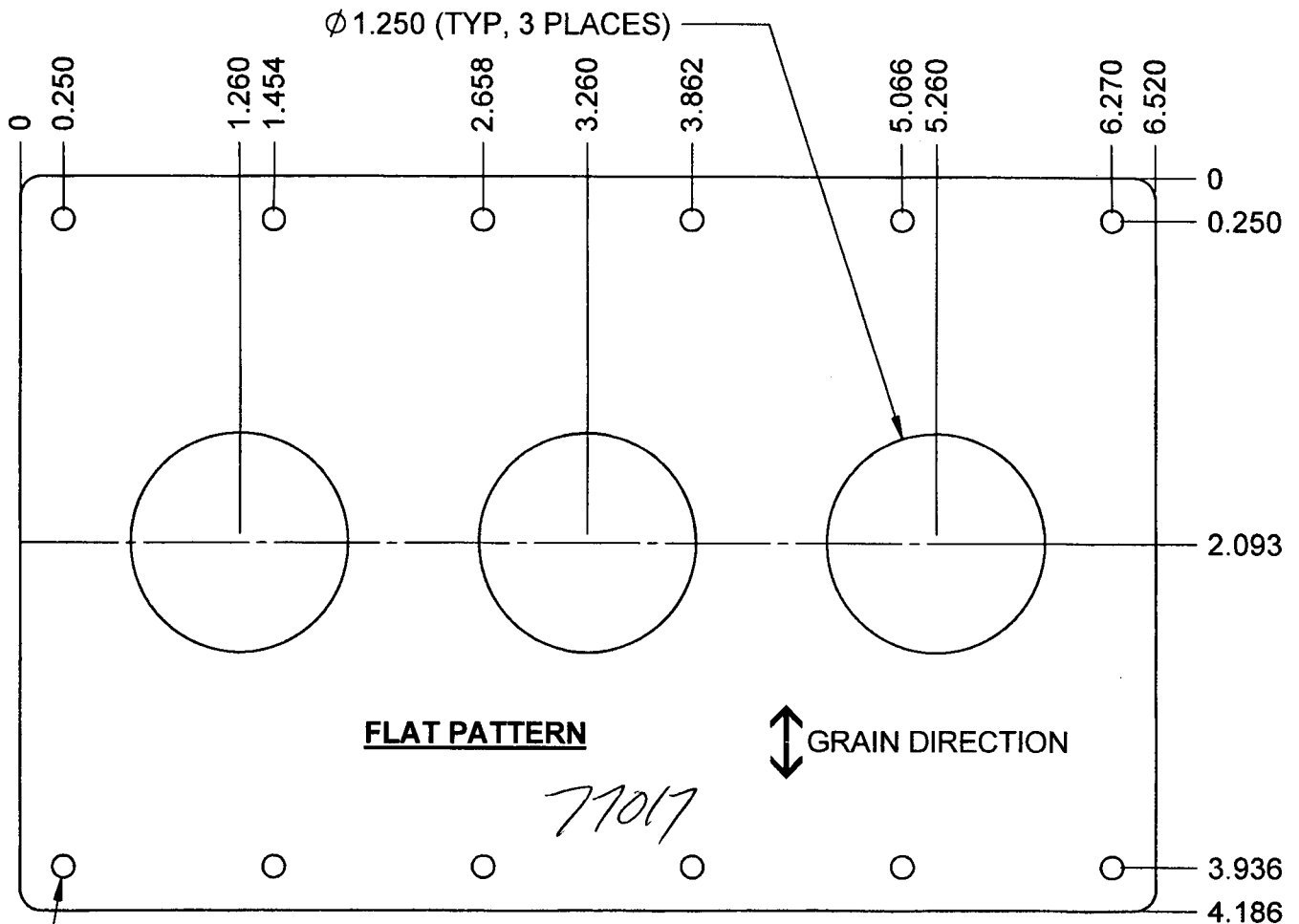
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NOTE: Date & initial all entries

DART

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DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

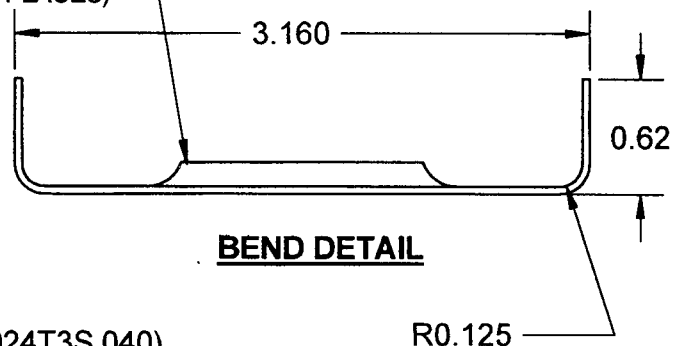


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06 05 20



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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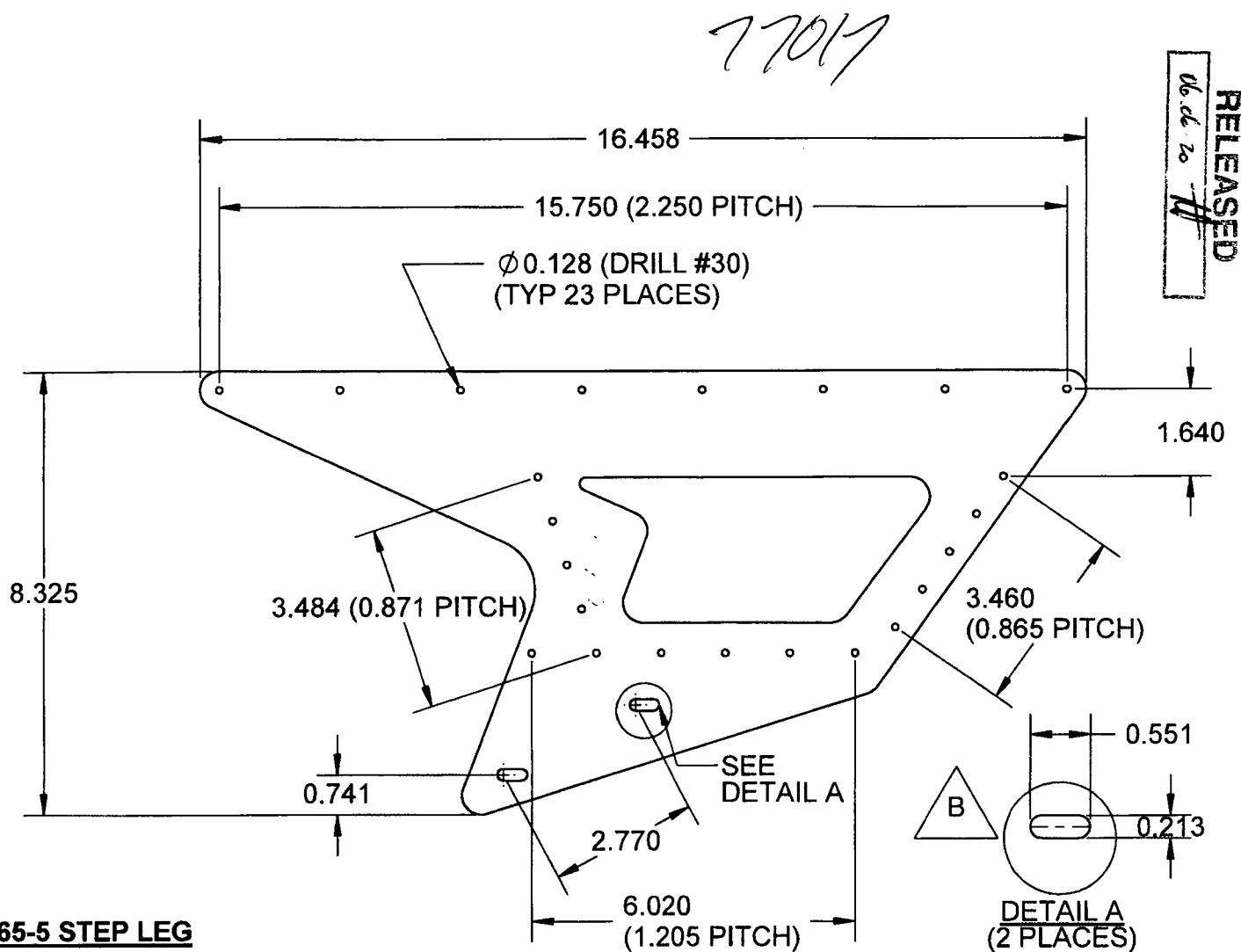
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
06.05.23	06.05.23	D3065	SHEET 4 OF 5
DATE	TITLE	SCALE	
	STEP LEG ASSEMBLY	1:3	



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

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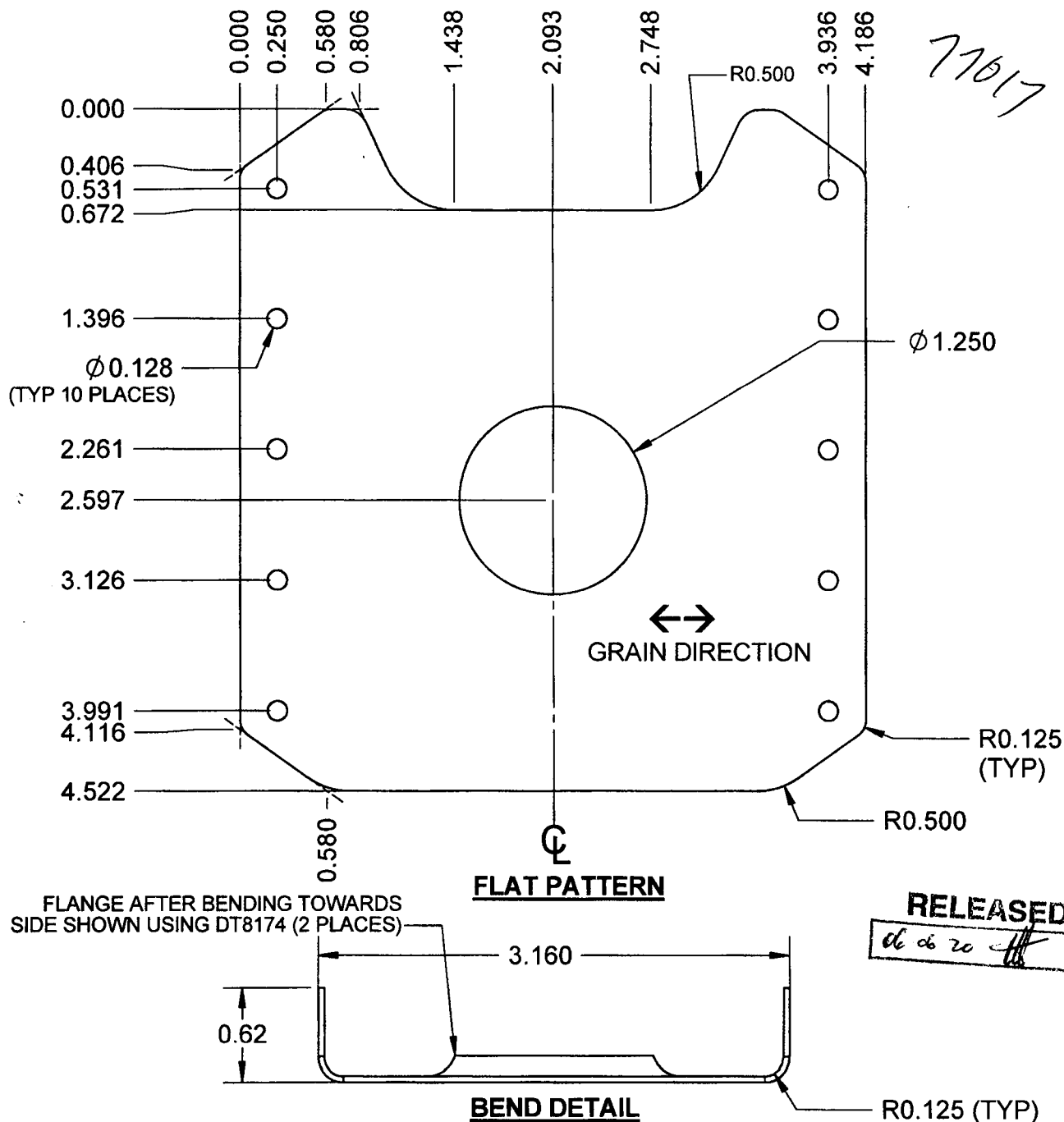
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries